

Work Order ID 50167

July 9, 2009 11:49:42 AM



Page 1

Item ID: D3936-5
Revision ID: A-PRELIM
Item Name: Divider



Accept



Setup Start



Stop



Start Date: 07/09/2009 Start Qty: 1.00
Required Date: 07/09/2009 Req'd Qty: 1.00



PRELIMINARY ISSUE

Cust Item ID:
Customer:

Reference:

Run Start



Approvals: Process Plan: *MF 09-07-09* Date:

Tooling:

Date:

Stop



QC: Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3936	A-PRELIM
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100

0.00



Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3936
Dwg Rev: *A-Prelim*
Prog Rev: *A-Prelim*

=> ml 09 07 09 (1)

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

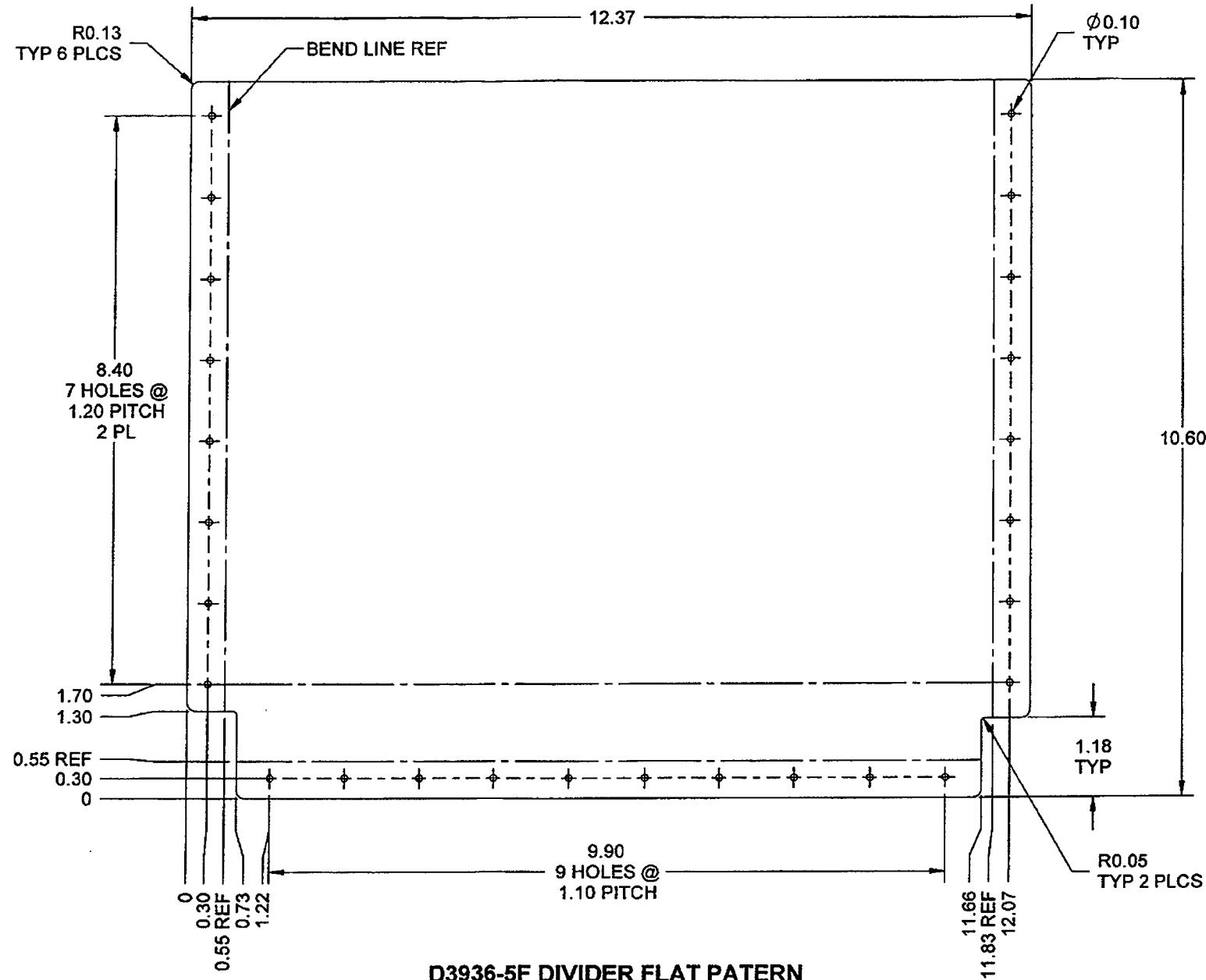
Memo

0.00

=> ml 09 07 09 (1)

606' 040 B# 0111224 ml 09 07 09

PRELIMINARY ISSUE



D3936-5F DIVIDER FLAT PATTERN

MP
09/07/09

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6060-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC M6061/T65.040
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.50 lbs

DESIGN	DF	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	BE	D3936	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		MAPBOX	NTS
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Jason Murdoch

From: Mike Petsche [mpetsche@dartaero.com]
Sent: July 9, 2009 3:28 PM
To: 'Jason Murdoch'
Subject: map box

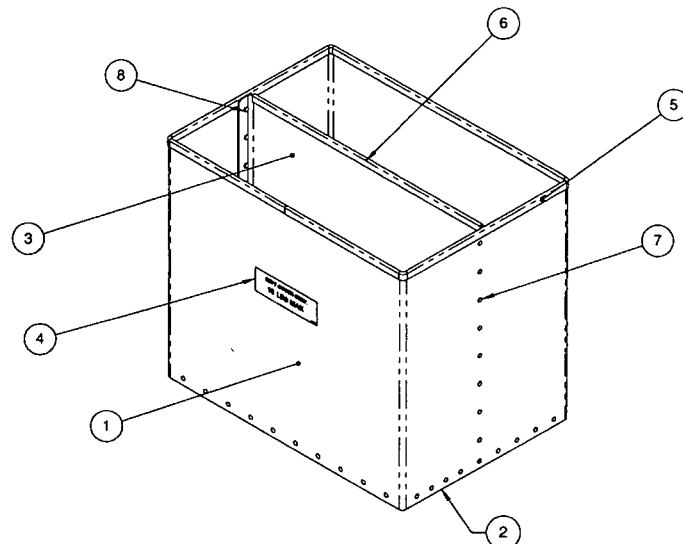
Please ship flat patterns to Harvey so Eagle can bend them up

Thanks

Mike Petsche
Design Manager
DART Aerospace
phone: 613-632-5200
mobile: 514-833-1657
skype: mike.petsche

09/07/2009

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	1	D3936-1	SIDES
2	1	D3936-3	BOTTOM
3	1	D3936-5	DIVIDER
4	1	D3938-3	PLACARD
5	1	D3941-40	RUBBER CUSHION
6	1	D3941-12	RUBBER CUSHION
7	56	MS20426AD3-4	RIVET
8	8	MS20426AD3-5	RIVET



D3936-041 MAPBOX ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3936-041" AND B/N USING A WHITE FINE POINT PAINT MARKER
- 7) WEIGHT: 2.54 lbs

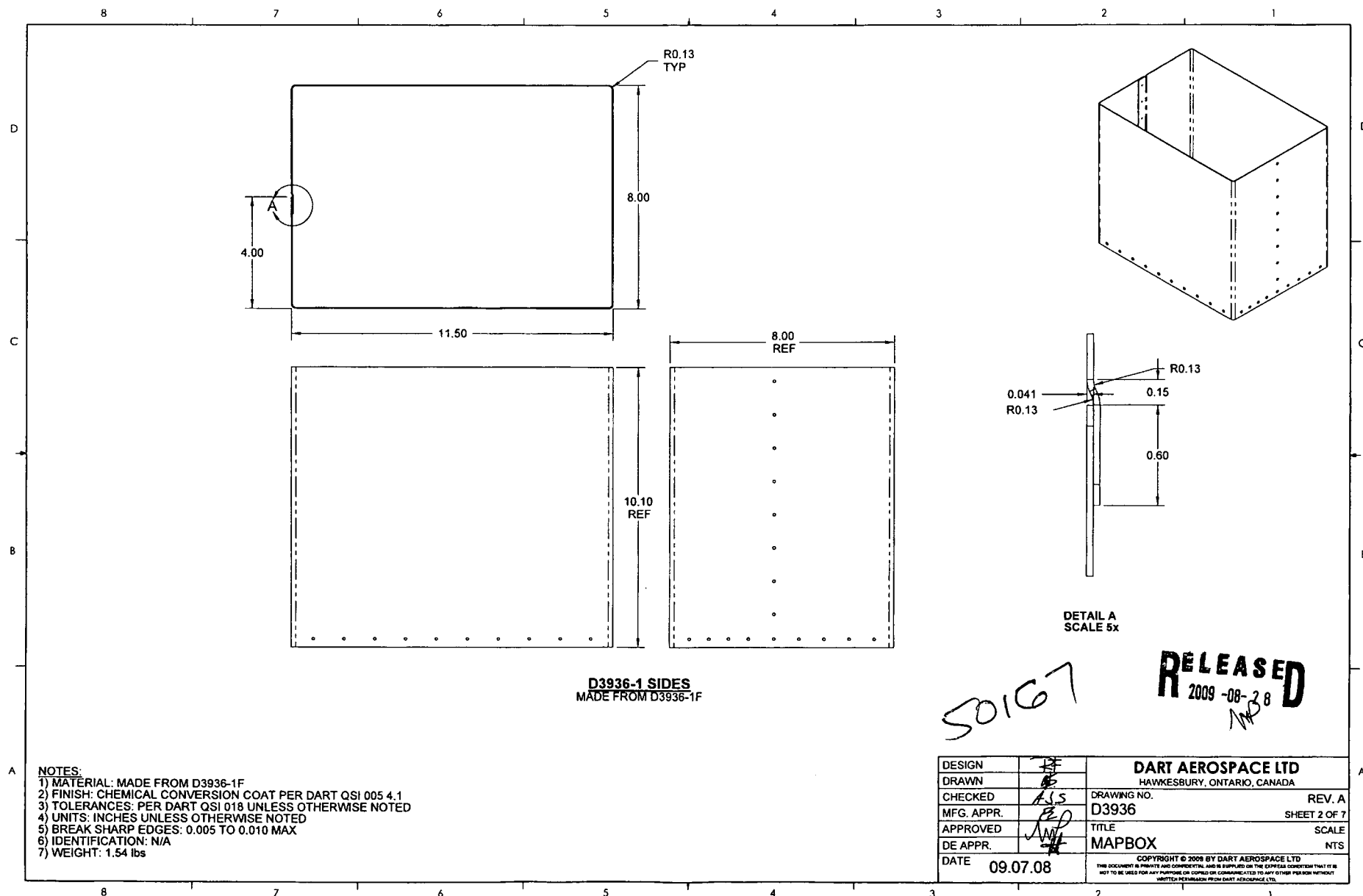
ASSEMBLY INSTRUCTIONS

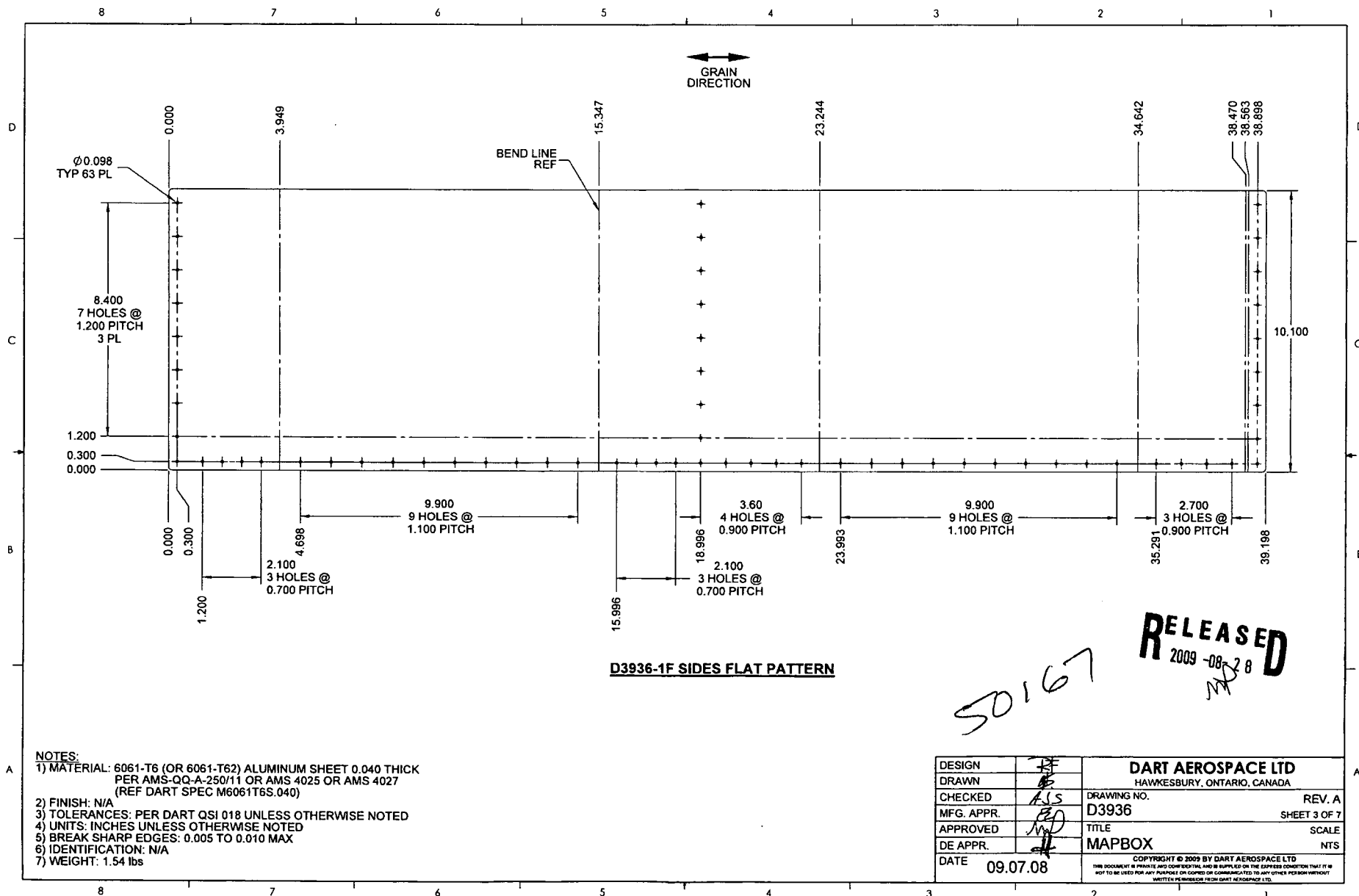
1. BEND D3936-1/-3/-5 PARTS PER SHEETS 2-7.
2. POSITION D3936-5 DIVIDER IN PLACE INSIDE THE D3936-1 SIDES AND CLECO IN PLACE.
3. POSITION THE D3936-3 BOTTOM IN PLACE AGAINST THE D3936-5 DIVIDER AND INSIDE THE D3936-1 SIDES.
4. TRANSFER DRILL 10X $\phi 0.098$ (#40 DRILL) HOLES FROM THE D3936-3 BOTTOM TO THE D3936-5 DIVIDER. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
5. TRANSFER DRILL 38X $\phi 0.098$ HOLES FROM D3936-1 SIDES TO D3936-3 BOTTOM. PLACE CLECOS IN TRANSFER DRILLED HOLES TO MAINTAIN ALIGNMENT AS THEY ARE DRILLED.
6. REMOVE ALL CLECOS AND COUNTERSINK 64X EXTERIOR HOLES $\phi 0.179 \times 100^\circ$. DEBURR ALL HOLES IN ALL PARTS.
7. REASSEMBLE PARTS USING CLECOS IN EVERY THIRD HOLE TO MAINTAIN ALIGNMENT.
8. RIVET D3936-1 SIDE TO D3936-5 DIVIDER USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
9. RIVET D3936-5 DIVIDER TO D3936-3 BOTTOM USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
10. RIVET D3936-3 BOTTOM TO D3936-1 SIDE USING MS20426AD3 RIVETS. INSTALL MS20426AD3 RIVETS RANDOMLY THROUGHOUT ASSEMBLY SO THAT ALL PARTS ARE DRAWN TOGETHER EVENLY.
11. POWDER COAT ASSEMBLY PER NOTE 2.
12. TEST FIT RUBBER CUSHION TO TOP EDGE OF MAPBOX. TRIM AS REQUIRED FOR PROPER FIT.
13. REMOVE RUBBER CUSHION.
14. APPLY SMALL BEAD OF SILICONE/ADHESIVE TO TOP EDGE OF MAPBOX.
15. SLIDE RUBBER CUSHION OVER EDGE AND PRESS INTO SILICONE/ADHESIVE.
16. WIPE OFF ANY EXCESS SILICONE/ADHESIVE BEFORE IT DRIES/CURES.
17. APPLY D3938-3 PLACARD AS SHOWN.
18. ALLOW SEALANT/ADHESIVE TO CURE/DRY 24 HRS BEFORE SHIPPING PART.

A	NEW ISSUE	BY	DATE
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3936	SHEET 1 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAPBOX	NTS
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RELEASED
2009-08-28
AmD

50167





NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.040)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.54 lbs

DESIGN	7F	DART AEROSPACE LTD	
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CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	ED	D3936	SHEET 3 OF 7
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2009-08-28
MD

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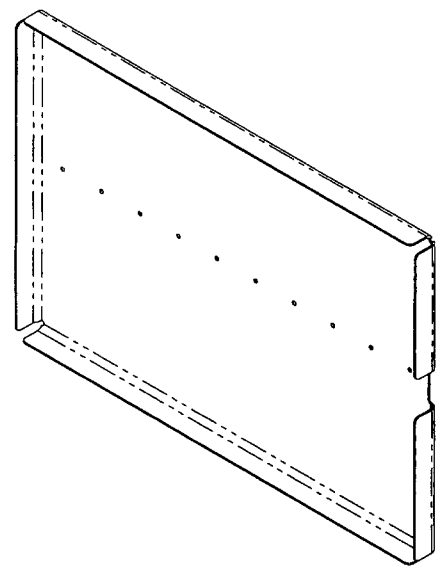
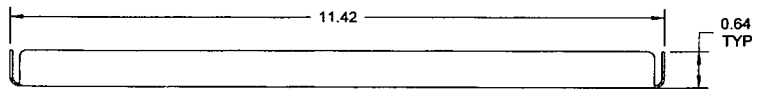
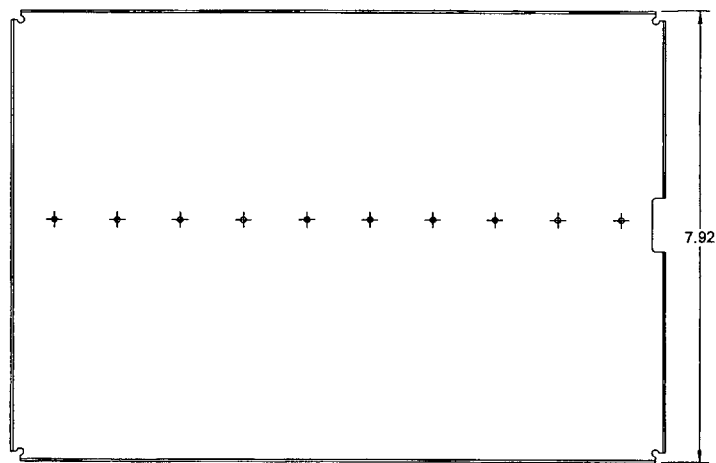
8 7 6 5 4 3 2 1

D

C

B

A



D

C

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A

D3936-3 BOTTOM
MADE FROM D3936-3F

NOTES:

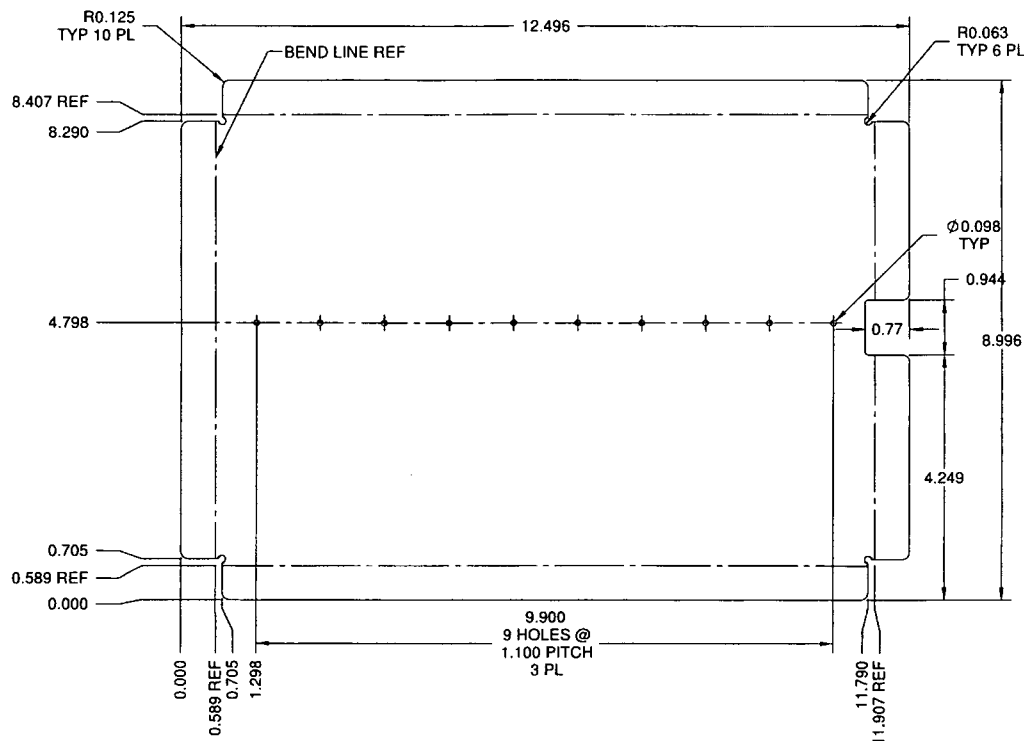
- 1) MATERIAL: MADE FROM D3936-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.43 lbs

50167

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2008-08-28
NM

DESIGN	JS	DART AEROSPACE LTD	
DRAWN	JS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3936	SHEET 4 OF 7
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8 7 6 5 4 3 2 1



D3936-3F BOTTOM FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.040)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.43 lbs

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2009-08-28
MP

50167

8 7 6 5 4 3 2 1

D

C

B

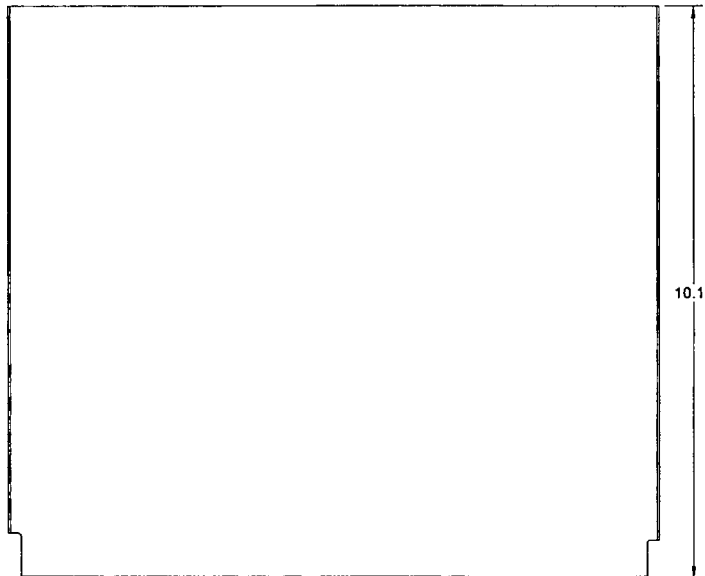
A

D

C

B

A

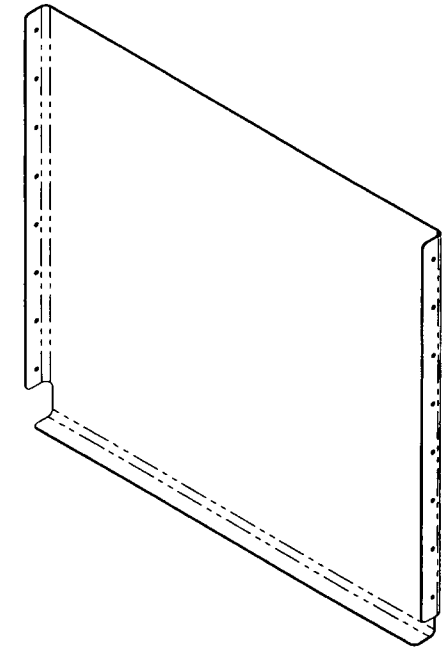


10.10

11.38

0.60
TYP

R0.13
TYP



D3936-5 DIVIDER
MADE FROM D3936-5F

RELEASED
2009-08-28

50167

NOTES:

- 1) MATERIAL: MADE FROM D3936-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.50 lbs

DESIGN	DF	DART AEROSPACE LTD	
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MFG. APPR.	AS	D3936	SHEET 6 OF 7
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8 7 6 5 4 3 2 1

